

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017729**Date Inspected:** 29-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

West Gate of Blast shop #1

This QA Inspector observed the following work in progress,

ORTHOTROPIC BOX GIRDER (OBG)

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint # 002- as per WRR no. B-WR-16260, located on Segment 12BE, SEG 3002B.

Welder is identified as 054016. ZPMC Quality Control (QC) Inspector is identified as Li Shi You. The welding variables recorded by QC appeared to comply with the WPS – 345-SMAW-4G (4F) -Repair.

West Gate of Bay #13

This QA Inspector observed the following work in progress,

ORTHOTROPIC BOX GIRDER (OBG)

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Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint # 92, located on Segment 12AW, FB3081-001. Welder is identified as 045133. ZPMC Quality Control (QC) Inspector is identified as Li Shi You. The welding variables recorded by QC appeared to comply with the WPS – 345-SMAW-2G (2F) -Repair.

Bay #16

This QA Inspector observed the following work in progress

ORTHOTROPIC BOX GIRDER (OBG)

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint # 144, 145- located on Crash Barrier W5-SB1C-002. Welder is identified as 201905. ZPMC Quality Control (QC) Inspector is identified as Li Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T - 2113.

Bay #14

This QA Inspector observed the following work in progress

ORTHOTROPIC BOX GIRDER (OBG)

Flux cored Arc Welding (FCAW):

Weld joint # 064, 062 -located on Lift 13 - LD 3036, Panel point 123.5. Welder is identified as 201215, 047858. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232-TC-U4B-F.

Weld joint # 059 -located on Lift 13 - LD 3036, Panel point 123 to 124. Welder is identified as 047866, 202122. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232-TC-U4B-F.

Weld joint # 017, 018 -located on Lift 13 – FB 3234, SEG 3015C Welder is identified as 045175. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

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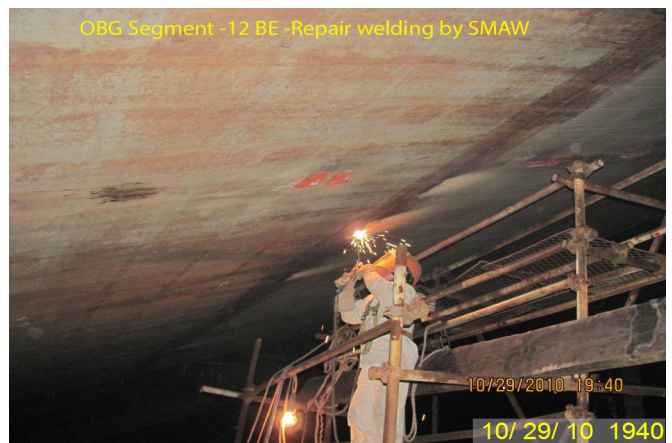
Shielded Metal Arc Welding (SMAW):

Weld joint # 025 -located on Lift 13 – SEG 3014D. Welder is identified as 045246. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2113 –FCM -1.

Weld joint # 026 -located on Lift 13 – SEG 3014D. Welder is identified as 051348. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2113 –FCM -1.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

No relevant Conversations.

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar, Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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